Work Order I	•		*103694*										
Revision ID:	161-9 ge 17.0"		Accept	*N900	040	100)* s	etup Sta	I VI	S1* S2*	•		
Start Date: 6/24 Required Date: 7/00 Reference:	4/13 Start Qty: 8.0 6/13 Req'd Qty: 8.0	• •		Cust Item I Customer:	D:						· ************************************		
	rocess Plan: MUS	Date: 13-06-	75 Tooling:SPC (Y/N):		ate:	· · · · · · · · · · · · · · · · · · ·	R	tun Sta Sto	IV	R1* R2*			
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp			
Draw Nbr	Revision Nbr												
D3161	Rev A2		0.00							0			
100 *1∩∩* Småll Fab	Small Fab	· ·	0.00				8x			45	7/07		
Small Fab		' Hinge makes (4) D3161-9 p	oarts at 17" longCut to leng	th as per Dwg	. •			Ŧ			, ,		
*110 *110*	QC5- Inspect part of	completeness to step on W/O	0.00	310/15			(V5))					
QC	Memo	•	0.00	()(0)10			-(1)	/	_				
Quality Control				•									
120	Identify as per dwg	& Stock Location: 57 03	0.00				_						
120 Packaging Packaging	Memo	,	0.00	report.						13-0	7-05/		

DQA:			Date:										17	AART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	odate only	7	AEROSPACE
Work Orde	r:					DISPOSITION								
Part No					Rework Scrap Use-as-is Suspected Unapproved	Scrap Use-as-is Ther		Skid-tube Crosstube Machining Small Fab moforming Finishing Large Fab Composite		-	Water Jet d. Eng. Coor. re/Packaging Supplier	E	ngineering Quality Other	
Root	7				Docc	ription of work order update		nitial	Action		Cian 0			
Cause		Date	Step	Qty	Desci	· ·		nitiai iief Eng			Sign & Date	Verification		QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved						or non-conformance						Vermidation		<u> </u>
							FA	ULT CAT	TEGORY			- <u>-</u>		
Landir	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	Program Pro	Positioned Wrong			ssure/Forced :-up nperature/Cure Id ong Stock Pulled		
	Wave/Twist in Tube					Fit/Function		•	Sequence			<u> </u>		

Work Orde June-24-13 2:1		3694		*103			Page 2				
Item ID: Revision ID: Item Name:	D3161-9 Hinge 17.0"			Accept	*N900	040	100)* s	Setup Start	i Vi s	• •
Start Date: Required Date: Reference:	6/24/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item ID: Customer:			_	Stant		
Approvals:	Process Pl	an:	Date:	Tooling:	D	ŀ	Run Start	"INK I"			
	QC:		Date:	SPC (Y/N):	D	ate:			Stop	*NF	₹2*
Sequence ID/ Work Center I 130 *130* QC	D ·	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	7/8	Insp. Stamp
Quality Control									,	mf V	3-7-5

DQA:		Dat	e:		- wark are to the containing that it is the											
OA Clasadi		Dot			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	14/	O			OSPACE			
QA Closed:		Dat	.e.						VV	ork Order up	date only		<u> </u>			
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
					Rework			Skid-tube Crosst	ube]	Water Jet	Engineer	ing			
Part N	lo.				Scrap	1 1		Machining Small		Pro	d. Eng. Coor.	Qua				
				Use-as-is		Therr	noforming Finisl	hing	Rec/Stor	e/Packaging	Ot	her				
NCR No.					Suspected Unapproved]	Large Fab Composite			Supplier						
Root			[Desc	ription of work order update		nitial	Action		Sign &						
Cause	Da	te Ste	p Qty		or non-conformance	l	ief Eng	į.		Date	Verification	QC Ins	pector			
Design					or non comormance	-	1101 2118	Bescription		Dute	Vermeation	QC IIIS	Sector			
Doc/Data																
Equip/Tooling								:								
Handling/Pre	\neg															
Material		ļ.		:												
Operator													i			
Offset/Setup												Ì				
Process												1				
Supplier						ļ					i					
Training																
Transport																
Unapproved																
			·			FA	ULT CA	TEGORY					-			
Landir	ng Gear				General		_				_					
	Bend	ling			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Fo	orced			
	Cent	re Not Con	centric		BOM/Route		Grain			Over/Under	tolerance	Set-up				
	Cracks			Broken/Damage/Defect		Hardwa	are		Part Incorred	it [Temperatui	re/Cure				
	Crimp/Kink/Ripple/Wave			·	Burrs	L	Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld				
	Cuffs			Contamination		Instruct	tions Incomplete/Unclear		Part Moved	Į	Wrong Stoc	k Pulled				
	Crushing			Countersink	$ldsymbol{ld}}}}}}$	Misalig	gned/off center		Positioned V	Vrong						
		Treat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other				
		ection Strip	in Tube		Drawing		Misrea	d								
	_	cs/Chatter		L	Drill Holes		Off-set									
	_	ing Sequen			Finish		Out of	Calibration								
	Wave/Twist in Tube				Fit/Function	1	Out of	Sequence								

Picklist Print

June-24-13 2:12:06 PM

Work Order ID:

103694

Parent Item:

D3161-9

Parent Item Name:

Hinge 17.0"

Start Date: 6/24/13

Required Date: 7/06/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A04.08.24New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200		Purchased	No			100	f	69.7437	1.65	13.2	5/	_ /	
Piano Hinge											- L	3/0	7/0
	,			Location		Loc Qty	<u>Lo</u>	c Code					
				ST209a		69.7436928							
				1239	960	6.4552628) ~			
				1254	145	63.28843			ن ا	ر کے ک			

Page 1

DQA:			Date:			WORK ORDER NON	-	. N.F.O.	D144165 / UDD 475				TRAC
QA Closed:			Date:			WORK ORDER NON	-C(JNFOI	RIMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	ar.					DISPOSITION			AGAIN				
WOIR OIGE	-					Rework	1		Skid-tube Crosstu	b o	1	Water Jet	Engineering
Part No.						Scrap	1	Skid-tube Crosstube Machining Small Fab			Dro	d. Eng. Coor.	Quality
rait No.					_	Use-as-is		Thermoforming Finishing			4	re/Packaging	Other
NCR No.					Suspected Unapproved			Large Fab Composite			Supplier		
Root					Desci	ription of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material	Ш												
Operator	Ш												
Offset/Setup	Ш												
Process													
Supplier													
Training													
Transport	Ш												
Unapproved													
							FA	ULT CA	TEGORY				
Landi	ng G	ear			_	General	_	•		_	-		7
		Bending			<u> </u>	Bend	<u></u>	Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	$\bigsqcup_{}$	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks					Broken/Damage/Defect		Hardwa	are		Part Incorred	ct	Temperature/Cure
	Crimp/Kink/Ripple/Wave			_	Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	· -	Weld	
	Cuffs				_	Contamination		4	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing				L	Countersink		Misalig	gned/off center		Positioned V	Vrong	-
Heat Treat					Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
	Inspection Strip in Tube			Drawing		Misrea	d						
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
	Wave/Twist in Tube					Fit/Function		Out of	Saguence				

. . .





	DESIG	#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
	CHEC	KED KF	APPROVED	D3161	REV. A						
	DATE	02.04	ł.24	TITLE HINGE	SCALE NTS						
,	Α	. 0	2.04.24	NEW ISSUE							
	AL	His	04.02.27	ADDED D3161-5 .							
	<u>A 2</u>	PH.	704 NG 36	100 03161-7 2 03161-9	an make the contract of the co						



P/N	LENGTH 'L'
D3161-1	13.5"
D3161-3	15.0"
r 3161.5	9.9"
1 3/21-7	14,00
7761-9	17.6"
_	

DESCRIPTION

HINGE (REPLACES MS 20257-3-13.5 ON D2183) HINGE (REPLACES MS ZOZS)-3-150 ON D2950-041) HINGE HINGE HINGE



Notts:

(1) MAKE FROM MSZOZS7-3-7200 HINGE

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